

Work Order ID 120311

Wednesday, June 04, 2014 3:01:43 PM

120311

Page 1

Item ID: D3500-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle
 Start Date: 6/04/14 Start Qty: 24.00 ***24*** Cust Item ID:
 Required Date: 6/04/14 Req'd Qty: 24.00 ***24*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 140606 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3500	C

100	HAAS CNC VERTICAL MACHINING #1	0.00							DAS 25 9-89 14.07.18
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100

HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

Program Batch No. 120311 Double check by: ML 1-Machine Step No 1
 per Folio FA641 and inspect per attached Dimension Sheets2-Machine Step
 No 2 per Folio FA641 and inspect per attached Dimension Sheets3-Machine
 Step No 3 per Folio FA641 and inspect p

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

DAS
 25
 9-89 14.07.18

120

QC8- Inspect parts - second check

0.00

120

QC

Quality Control

Memo

0.00

24

0

DAS
 20
 9-89 1407-22

PTO →

DQA:

Date:

14/08/27



QA Closed:

Date:

14-8-16

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>120 311</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>P3500-1</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>14-4151</u>		Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	14.07.18	100	2	USED 7/16 RAD TOOL WAS SUPPOSED TO BE .250 RAD TOOL. RIB UNDER SIZE.	DAS 16 9-89	Scrap + Destroy. Replace. B 110225	14.07.18 DAS 37 9-89	DAS 16 9-89	DAS 16 9-89
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operators									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input checked="" type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 120311

Wednesday, June 04, 2014 3:01:43 PM

120311

Page 2

Item ID: D3500-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle
 Start Date: 6/04/14 Start Qty: 24.00 ***24*** Cust Item ID:
 Required Date: 6/04/14 Req'd Qty: 24.00 ***24*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00				24	76	14-7-23	
Hand Finishing									
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
140									
Powdercoat	Memo	0.00				24	0	14-7-24	
Powder Coating	START TIME: 10:05 OVEN TEMPERATURE: 30 FINISH TIME: 10:35								
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00				24			
Quality Control									

DAS 34 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 120311

Wednesday, June 04, 2014 3:01:43 PM

120311

Page 3

Item ID: D3500-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Saddle

Stop ***NS2***

Start Date: 6/04/14 Start Qty: 24.00

24

Cust Item ID:

Required Date: 6/04/14 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: _____	0.00							
160									
Packaging	Memo	0.00							DAS 32 9-89
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

14/7/25 27

MLJ 14-07-25

MLJ 14-07-25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

Wednesday, June 04, 2014 3:01:42 PM

Page 1

Work Order ID: 120311

120311

Parent Item: D3500-1

D3500-1

Parent Item Name: Saddle

Start Date: 6/04/14

Required Date: 6/04/14

Start Qty: 24.00

Required Qty: 24.00

Comments: -- IPP Rev:A New Issue 06-06-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6102-013		Manufactured	No			100	Each	114.0000	1	24			
D6102-013									**			DAS	
Saddle Billet												37	
												9-89	14.07.18

Location

Loc Qty

Loc Code

MAT040

52

104299

22

105041

20

105554

10

MAT041

20

117029

20

MAT046

42

109518

10

110225

12

110994

8

111533

12

20

4+2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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DART AEROSPACE LTD		Work Order: 120311
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.487	.487	.487	.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.373	.373	.373	.375		
F	0.490	0.510		.497	.496	.498	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.588	1.588	1.588	1.588		
J	0.240	0.260		.247	.247	.247	.246		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.62	3.62	3.62	3.620		
M	0.315	0.322		.318	.318	.318	.316		
N	0.256	0.262		.260	.260	.260	.259		
O	6.500	6.520		6.505	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.550	.550	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.055	.055	.055	.055		
Y	0.100	0.120		.100	.100	.100	.100		
AA	R1.125	R1.145		1.134	1.134	1.134	1.134		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.249	.254	.254	.254		
AE	1.810	1.830		1.823	1.823	1.823	1.821		
AF	0.240	0.260		.251	.250	.250	.251		
AG	0.140	0.160		.152	.151	.151	.151		
AH	0.140	0.160		.151	.152	.154	.155		
AI	0.140	0.160		.151	.151	.155	.155		
Accept/Reject									

Measured by: DAS		Audited by: 20	
Date: 37		Date: 989 14-07-22	
Date: 989 11-07-18		Date: 14-7-19	

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

[illegible]

(Note: Dimension 1 is 0.5 x 2.0 ft. 2 is 0.5 x 2.5 ft.)							
I	R1.575	R1.595	1.588	1.588	1.588	1.588	
J	0.240	0.260	-.246	-.246	-.246	-.246	
K	0.490	0.510	-.500	-.500	-.500	-.500	
L	3.590	3.650	3.620	3.620	3.620	3.620	
M	0.315	0.322	-.316	-.316	-.316	-.316	
N	0.256	0.262	-.259	-.259	-.259	-.259	
O	6.500	6.520	6.510	6.510	6.509	6.509	
P	5.990	6.010	6.000	6.000	6.000	6.000	
Q	2.820	2.830	2.825	2.825	2.825	2.825	
R	2.495	2.505	2.500	2.500	2.500	2.500	
S	2.245	2.255	2.250	2.250	2.250	2.250	
T	1.120	1.130	1.125	1.125	1.125	1.125	
U	0.540	0.560	-.550	-.551	-.550	-.550	
V	0.793	0.803	-.798	-.798	-.798	-.798	
W	R.240	R.260	-.25	-.25	-.25	-.25	
X	0.040	0.060	-.055	-.055	-.055	-.055	
Y	0.100	0.120	-.100	-.100	-.100	-.100	
AA	R1.125	R1.145	1.134	1.134	1.134	1.134	
AB	R.490	R.510	-.500	-.500	-.500	-.500	
AC	0.615	0.635	-.635	-.635	-.635	-.635	
AD	0.240	0.260	-.254	-.254	-.254	-.254	
AE	1.810	1.830	1.821	1.821	1.821	1.823	
AF	0.240	0.260	-.251	-.251	-.250	-.250	
AG	0.140	0.160	-.151	-.151	-.151	-.151	
AH	0.140	0.160	-.155	-.155	-.155	-.155	
AI	0.140	0.160	-.155	-.154	-.154	-.154	
Accept/Reject						DAS	

Audited by	20 9-89
Date:	14-07-22

H:/Dimension Sheets/approved DS

DART AEROSPACE LTD		Work Order:	120311
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	19	210	211	212		
A	0.483	0.490		486	486	486	486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		375	375	375	375		
F	0.490	0.510		498	500	499	499		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.588	1.588	1.587	1.587		
J	0.240	0.260		246	246	246	247		
K	0.490	0.510		500	500	500	500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		316	316	316	316		
N	0.256	0.262		259	259	259	259		
O	6.500	6.520		6.509	6.510	6.509	6.510		
P	5.990	6.010		6.000	6.000	5.999	5.999		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		550	550	550	548		
V	0.793	0.803		798	798	798	798		
W	R.240	R.260		250	250	250	250		
X	0.040	0.060		055	055	055	055		
Y	0.100	0.120		100	100	100	100		
AA	R1.125	R1.145		1.134	1.134	1.133	1.133		
AB	R.490	R.510		500	500	500	500		
AC	0.615	0.635		635	635	635	635		
AD	0.240	0.260		255	255	255	255		
AE	1.810	1.830		1.822	1.822	1.822	1.822		
AF	0.240	0.260		250	250	250	250		
AG	0.140	0.160		151	151	151	151		
AH	0.140	0.160		155	155	156	155		
AI	0.140	0.160		155	155	155	154		
Accept/Reject							DAS		
							20		

Measured by:	SK
Date:	14-7-20

Audited by:	9-89
Date:	14-07-22

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD				Work Order: 120311	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500				Rev: C	
Page 1 of 1					

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1/3	2/4	3/5	4/6		
A	0.483	0.490		.486	.486	.486	.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.500	.498	.498	.498		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.587	1.587	1.587	1.587		
J	0.240	0.260		.250	.249	.251	.251		
K	0.490	0.510		.500	.500	.498	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.259	.259	.259	.259		
O	6.500	6.520		6.509	6.507	6.509	6.506		
P	5.990	6.010		6.002	6.002	5.999	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.551	.551	.550	.551		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.055	.055	.055	.055		
Y	0.100	0.120		.100	.100	.100	.100		
AA	R1.125	R1.145		1.133	1.133	1.133	1.133		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.250	.255	.255	.255		
AE	1.810	1.830		1.822	1.822	1.823	1.823		
AF	0.240	0.260		.250	.251	.251	.251		
AG	0.140	0.160		.150	.150	.150	.150		
AH	0.140	0.160		.156	.155	.156	.156		
AI	0.140	0.160		.154	.154	.156	.155		
Accept/Reject								DAE	

Measured by:	SL
Date:	14-7-20

Audited by:	20
Date:	9-89 14-07-22

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD		Work Order: 120311
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	17	18	19	20		
A	0.483	0.490		.486	.486	.486	.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.499	.498	.499	.498		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.588	1.588	1.588	1.588		
J	0.240	0.260		.251	.251	.251	.251		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.259	.259	.259	.259		
O	6.500	6.520		6.508	6.508	6.508	6.508		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.550	.550	.551		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.055	.055	.055	.055		
Y	0.100	0.120		.100	.100	.100	.100		
AA	R1.125	R1.145		1.133	1.133	1.133	1.133		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.255	.255	.255	.254		
AE	1.810	1.830		1.823	1.823	1.822	1.822		
AF	0.240	0.260		.250	.250	.250	.250		
AG	0.140	0.160		.150	.150	.150	.150		
AH	0.140	0.160		.156	.156	.156	.155		
AI	0.140	0.160		.155	.156	.155	.155		
Accept/Reject									

Measured by: SL
Date: 14-7-20

Audited by: DAS
Date: 20 14-07-22

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD		Work Order: 20311
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	21	22	23	24	By	Date
A	0.483	0.490		486	486	486	486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		375	375	375	375		
F	0.490	0.510		499	499	499	499		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.588	1.588	1.588	1.588		
J	0.240	0.260		250	250	251	250		
K	0.490	0.510		499	500	500	500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		316	316	316	316		
N	0.256	0.262		259	259	259	259		
O	6.500	6.520		6.509	6.508	6.509	6.508		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		551	550	550	550		
V	0.793	0.803		798	798	798	798		
W	R.240	R.260		250	250	250	250		
X	0.040	0.060		055	055	055	055		
Y	0.100	0.120		100	100	100	100		
AA	R1.125	R1.145		1.133	1.133	1.133	1.133		
AB	R.490	R.510		500	500	500	500		
AC	0.615	0.635		635	635	635	635		
AD	0.240	0.260		253	254	254	254		
AE	1.810	1.830		1.823	1.823	1.823	1.823		
AF	0.240	0.260		250	250	250	250		
AG	0.140	0.160		150	150	150	150		
AH	0.140	0.160		156	155	156	155		
AI	0.140	0.160		155	155	155	154		
Accept/Reject									

Measured by: SK	Audited by: 20
Date: 14-7-21	Date: 14-07-22

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

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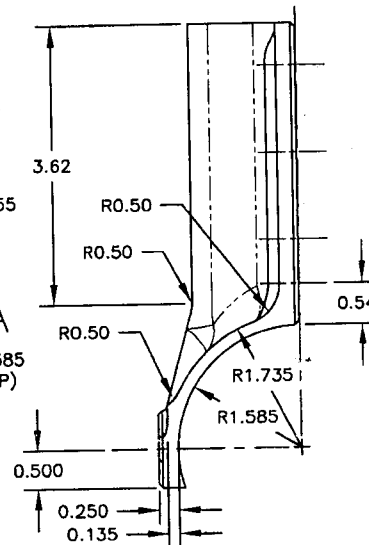
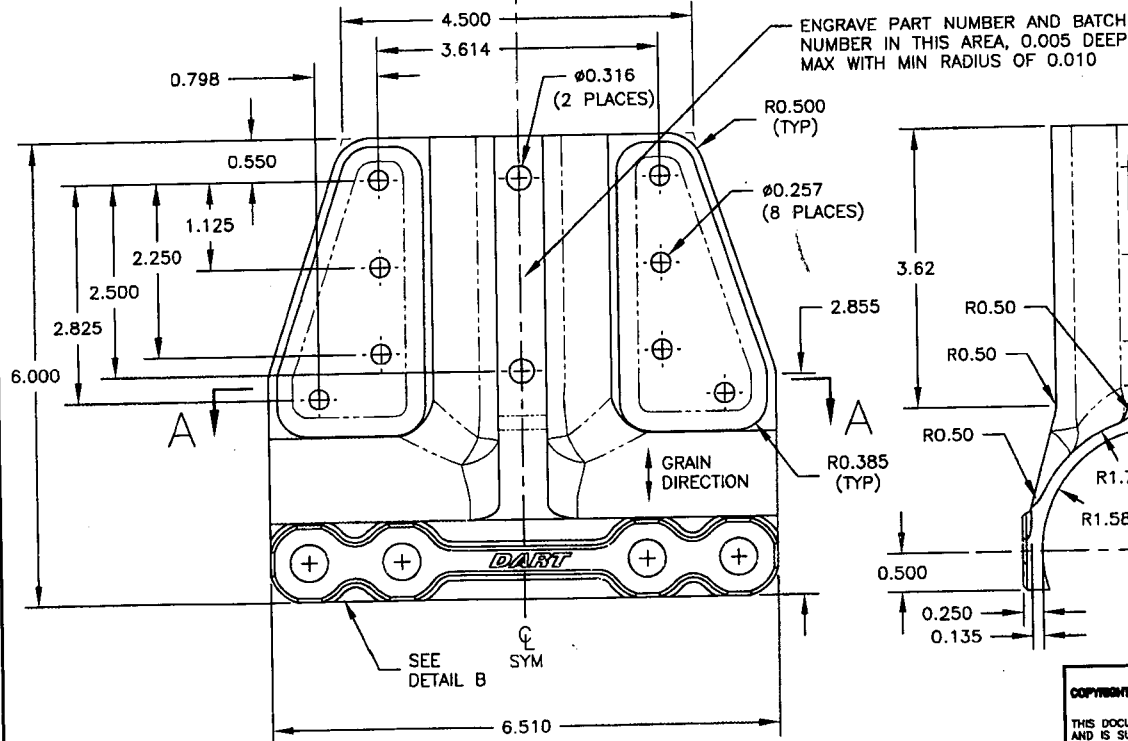
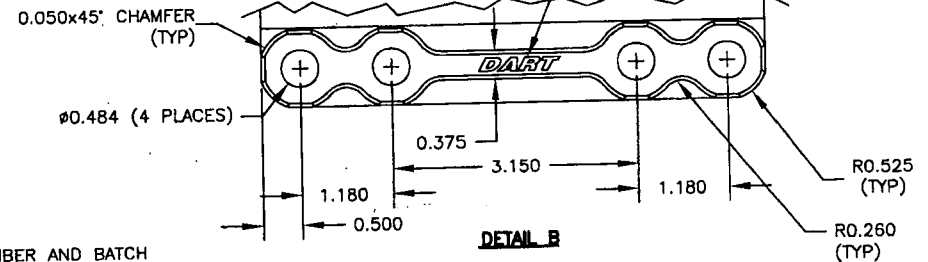
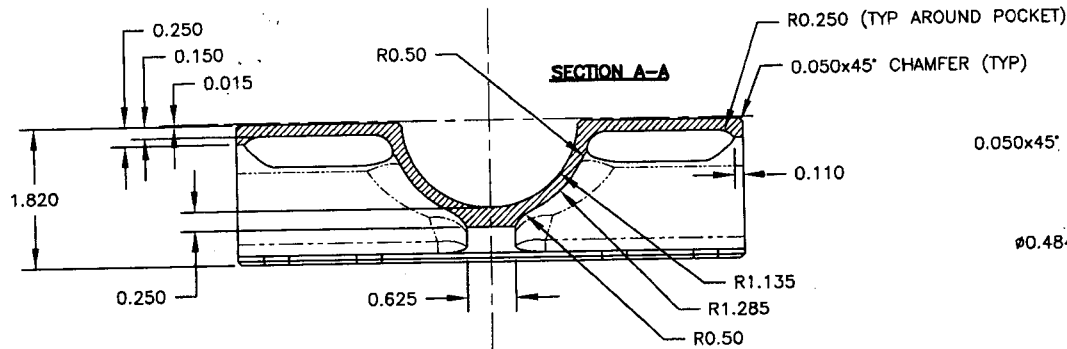
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 120311 ML3
14-06-06

ENGRAVE DART LOGO IN
THIS AREA TO A MAX
DEPTH OF 0.015 AND A MIN.
TOOL RADIUS OF 0.250



D3500-1 SADDLE

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/11) (MAKE FROM D6102-013 SADDLE BILLET, 6061)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1, POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED

06.68.15

C	06.06.30	MAT'L NOW 6061-T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE
DESIGN	PH	DART DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED	PH	DRAWING NO. D3500
DATE	06.06.30	TITLE SADDLE
		REV. C SHEET 1 OF 1 SCALE 2:3

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